

# Work Order ID 84618

May-17-12 10:39:50 AM

**\*84618\***

Page 1

Item ID: D3580-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Joggle Bracket  
 Start Date: 17/05/2012 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 31/05/2012 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3580	Rev B								

100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet	Memo	0.00				44	Ø		Jm
FLOW CNC Waterjet	1-Cut as per Dwg D3580								12-5-22
304 .050	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				44	Ø		Jm
Quality Control									12-5-22
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

counts  
 (x44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84618

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Item ID: D3580-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Joggle Bracket  
 Start Date: 17/05/2012 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 31/05/2012 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00				44			SB 12/6/06
	Memo	0.00							
	Bend as per dwg D3580 using 1/8" offset die								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				44			W 12.06.07
	Memo	0.00							
	Quality Control								
150 <b>*150*</b> Packaging	Identify as per dwg & Stock Location: <u>55</u>	0.00				44			12/6/08
	Memo	0.00							
	Packaging								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 84618****\*84618\***

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May-17-12 10:39:50 AM

Item ID: D3580-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Joggle Bracket

Stop **\*NS2\***

Start Date: 17/05/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

mf  
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

May-17-12 10:39:54 AM

Page 1

Work Order ID: 84618

**\*84618\***

Parent Item: D3580-1

**\*D3580-1\***

Parent Item Name: Joggle Bracket

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev :A New Issue 07.06.25 EC  
IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	249.2860	0.01	0.421053			

**\*M304S18GA\***

**\*\***

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

248.96421

120604

24.96421

121626

128

121660

96

MAT20

0.32179

121192

0.32179

121192

Jm

12-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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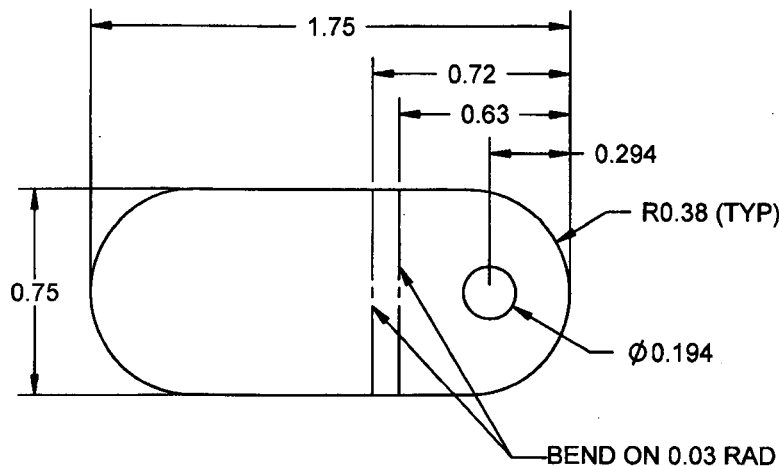
NOTE: Date & initial all entries



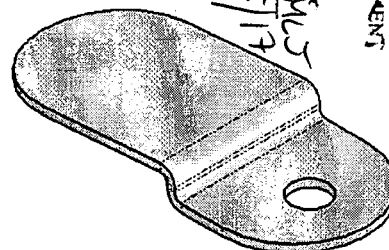
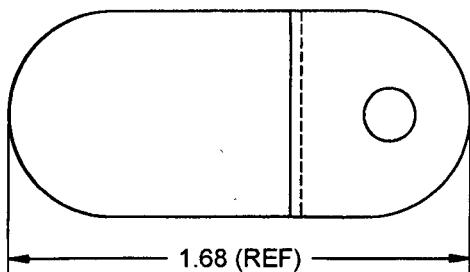
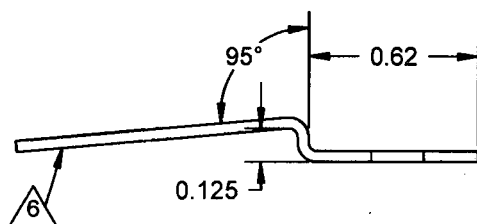
DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED

07.07.09 *[Signature]*



**D3580-1F FLAT PATTERN**



SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NO AMENDMENTS  
WITHOUT NC  
WORK ORDER  
NO. 84618 M25  
12/05/17

**D3580-1 JOGGLE BRACKET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)  
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER  
ON THE UNDERSIDE OF THE PART AS INDICATED

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